

Work Order ID 60907

July 26, 2010 1:36:47 PM



Page 1

Item ID: D407-649-011

Accept



Setup

Start



Revision ID:

Item Name: Hardpoint (6)

Stop



Start Date: 7/26/10 Start Qty: 1.00



Cust Item ID:

Required Date: 7/30/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

N/A

Rev N/A

100



DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy blue file D407-649 and type labels per QSI 014

CHG001

8/10/08/04

BG 10/08/04
(WHITE LABEL ONLY)

110



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

10/8/04 SPW

120



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

8/10/08/04

(H)

Work Order ID 60907

July 26, 2010 1:36:48 PM



Page 2

Item ID: D407-649-011

Accept

Revision ID:

Item Name: Hardpoint (6)

Start Date: 7/26/10 Start Qty: 1.00

Required Date: 7/30/10 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D407-649-011
Location: 21 PPP Rev: C

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/8/04

12

10/08/04

mf

10-8-04

July 26, 2010 1:36:45 PM





Page 1

Parent Item Name: Hardpoint (6)

Required Date: 7/30/10

Required Qty: 1.00

Comments: IPP Rev:B 98.12.07 Changed location for step 2 DM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
80-007-15-4A  Insert		Purchased	No			120	Each	38.0000	24	24			
				<u>Location</u>									
				ST379									
				112086				38					
				114794				14					
				<u>115039</u>				4					
								20					
AN4-6A  Bolt		Purchased	No			120	Each	1,243.000	24	24			
				<u>Location</u>									
				ST356									
				112933				1243					
				<u>113149</u>				96					
				114523				344					
				114615				2					
				114941				1					
				115108				500					
								300					
AN960JD416  Washer	NAS1149D0463J	Purchased	No			120	Each	0.0000	24	24			
D2713  Lug		Manufactured	No			120	Each	18.0000	4	4			
				<u>Location</u>									
				ST479									
				36699				18					
								18					

Picklist Print

July 26, 2010 1:36:45 PM

Page 2

Work Order ID: 60907

Parent Item: D407-649-011

Parent Item Name: Hardpoint (6)

Start Date: 7/26/10

Required Date: 7/30/10

Start Qty: 1.00

Required Qty: 1.00

D2755-1
Lug

Manufactured No

120 Each

6.0000

1

Location

Loc Qty

Loc Code

ST479

6

17551

6

120 Each

17.0000

1

Location

Loc Qty

Loc Code

ST479

17

14075

3

17552

4

48383

10

120 Each

17.0000

6

Location

Loc Qty

Loc Code

ST024

17

9234

17

120 Each

40.0000

6

Location

Loc Qty

Loc Code

ST024

40

9235

40

Manufactured No

D2756
Inner Doubler

D2757
Outer Doubler

10/8/4 SP

10/8/4 SP

6 10/8/4 SP

6 10-8/4 SP

6

(10)

July 26, 2010 1:36:45 PM

Shop Packet Print

Page 2

Picklist Print

July 26, 2010 1:36:45 PM

Page 3

Work Order ID: 60907

Parent Item: D407-649-011

Parent Item Name: Hardpoint (6)

Start Date: 7/26/10

Required Date: 7/30/10

Start Qty: 1.00

Required Qty: 1.00

M7885/2-4-1

Purchased

No

120

Each

1,541.000

96

96



Rivet



10/8/4 sl

Location

Loc Qty

Loc Code

ST393

1541

101692

1

110267

1540

M7885/3-4-2

Purchased

No

120

Each

857.0000

126

126



Rivet



10/8/2 sl

(12)

Location

Loc Qty

Loc Code

ST393

857

110267

857

126

July 26, 2010 1:36:45 PM

Shop Packet Print

Page 3



REFERENCE ONLY

IIN-D407-649
Page 8 of 8

6 PARTS LIST

Qty	Part Number	Description
X	D407-649-011	407 HARDPOINT KIT INSTALLATION
4	D2713	BRACKET
1	D2755-1	AFT BRACKET LH
1	D2755-2	AFT BRACKET RH
6	D2756	INNER DOUBLER
6	D2757	OUTER DOUBLER
96	M7885/2	RIVET
126	M7885/3	RIVET
24	AN4-6A	BOLT
24	AN960JD416	WASHER
24	80-007-15-4A	INSERT - DOME HEAD

7 HARDPOINT LOAD LIMITS (REFERENCE ONLY)

The maximum limit loads on the Hardpoint Kit are 500 lb vertical load and 280 lb radial horizontal load for each individual hardpoint. The radial horizontal and vertical loads may be applied simultaneously. Any equipment attached to the hardpoints **shall not exceed these loads**.

8 CARGO HOOK LIMITATIONS (REFERENCE ONLY)

Loads applied to the Dart Hardpoint Kit Installation will limit the load carrying capacity of the cargo hook according to the following Figure. When the hardpoints are loaded to their maximum capacity, outlined in section 7 of this document, the cargo hook is limited to carrying a maximum load of 1850 lb.

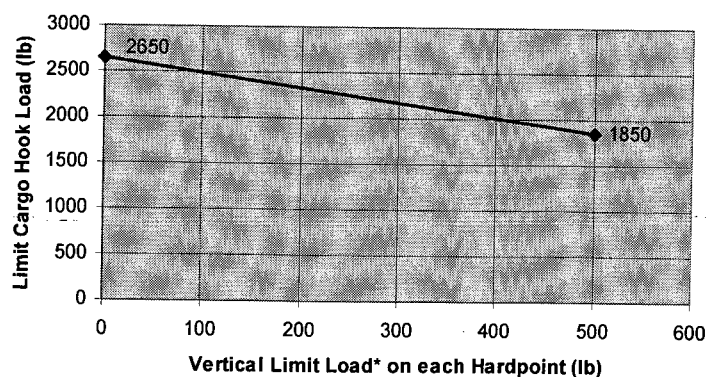


Figure 5 - Cargo Hook Limitations for Hardpoint Loads

* The Vertical Limit Load on each Hardpoint refers to the maximum allowable vertical limit load for a single hardpoint only. The 500 lb vertical limit load indicated in Figure 5 implies a maximum radial horizontal load of 280 lb, according to section 7 of this document. These limit loads should not be exceeded.

Revision : B
Date : 98.04.29



DESIGN KE	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED DA	DRAWING NO. DSI 9114	REV. A SHEET 1 OF 1
DATE 98.11.03		TITLE 407 HARDPOINT KIT	SCALE NTS
A	98.11.03	NEW ISSUE	

REFERENCE ONLY

DART SERVICE INSTRUCTION

AMEND DART INSTALLATION INSTRUCTIONS IIN-D407-649 REV. B

STA: SH98-18
STC: SR00895NY

DETAILS OF THE CHANGES TO THE PARTS LIST ON **PAGE 8** OF
INSTALLATION INSTRUCTIONS IIN-D407-649 REV. B ARE OUTLINED BELOW:

CHANGE:

96	M7885/2	RIVET
126	M7885/3	RIVET
24	80-007-15-4A	INSERT - DOME HEAD

TO:

96	M7885/2-4-1	RIVET
126	M7885/3-4-2	RIVET
24	80-007-15-4A or SL3149-4A-15 or K100H4A95-15 or ET5215-12A-15 or FIT7623-4A-15	INSERT - DOME HEAD